

Date: Wednesday, 5/16/2007 7:57:42 AM
 User: Kim Johnston

Process Sheet

24

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT X-TUBE EXT HEIGHT(-013)
Job Number	: 32357		
Estimate Number	: 10563		
P.O. Number	: N/A	Part Number	: D205596107
This Issue	: 5/16/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D205596107
First Issue	: N/A	Project Number	: N/A
Previous Run	: 31379	Drawing Revision	: A
		Material	: N/A
		Due Date	: 6/15/2007
Written By	: <u>ADD 7.05.16</u>	Qty:	1 Um: Each
Checked & Approved By	: <u>ADD 7.05.16</u>		
Comment	: Est Rev: D 05.03.21 Added bending procedure KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-107CHG001

2

2.0	D2890	Aft Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2890 Aft Crosstube 532346

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Mark 20.36" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

JAN. 26 0

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

E 57/07/26

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-107

EL 7-7-31

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

5078-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 7:57:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT(-013)

Job Number: 32357

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



7-08-01 @



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

A

~~Touch up ends of the tube with~~ Chemical Conversion Coat per QSI 005 4.1

JB 7-8-1

8.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

7-07-08-08

9.0

QC14

INSPECT SPRAY PAINT



ml 07 08 09



(1)

Comment: Inspect Spray Paint

10.0

D2856600

Abrasion Strip



Comment: Qty.: 1.6810 f(s)/Unit Total : 1.6810 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-600(10.09") Abrasion Strip

B28650

7-07-08-13

11.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2940-1

Support

1532169

7-07-08-13

12.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4 MS21920-28

Clamp

103816

7-07-08-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 02/08/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 7:57:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT(-013)

Job Number: 32357

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-107. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

27 07-08-13

A/R Sikaflex-291

Expiry date:

W/A En

P107

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

27 07/08/13 (CL)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-107

Location: _____

PPP Rev: _____

Rev C 7/8/13

SP 7/08/13

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

27.08.13

Job Completion



C207/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/13	130	Remove S.1. after 291 / export / del Vocal 070827	CR	07/08/13			[Signature] 26/8/13

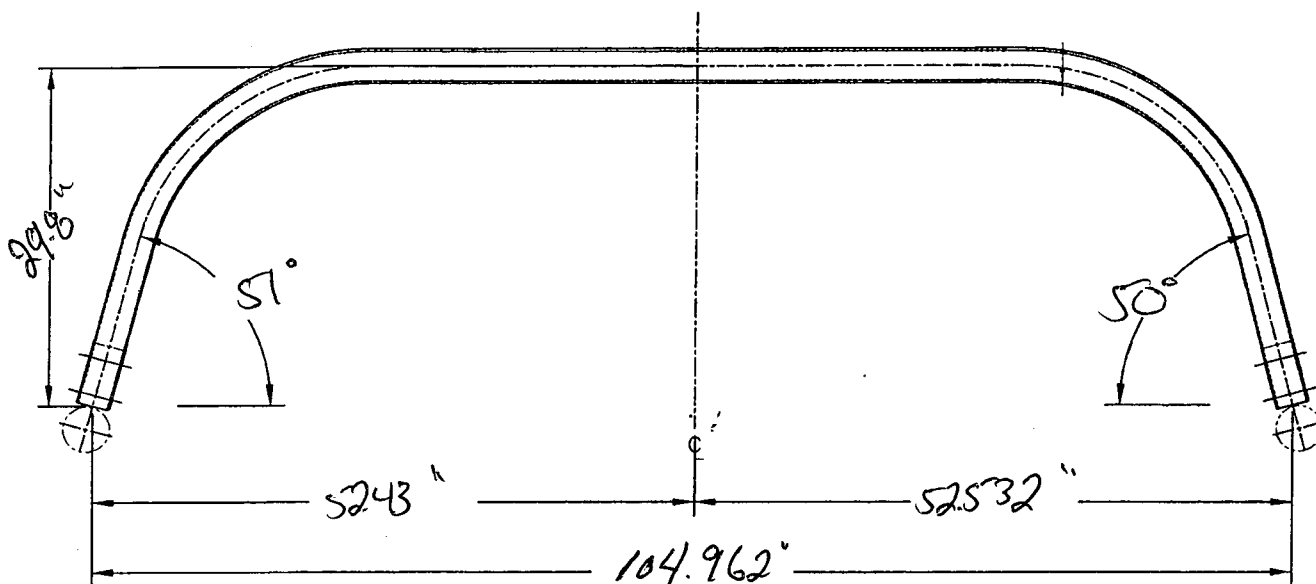
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
QA: N/C Closed: _____ Date: _____

[illegible]

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	- 32357
Description: Crosstube High-High Aft		Part Number:	D205-596-107
Inspection Dwg: D205-596-107 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	29.7	29.9
1/2 Span	52.4	52.6
Angle	49	52
Total Span	104.8	105.2

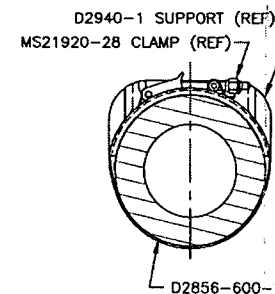
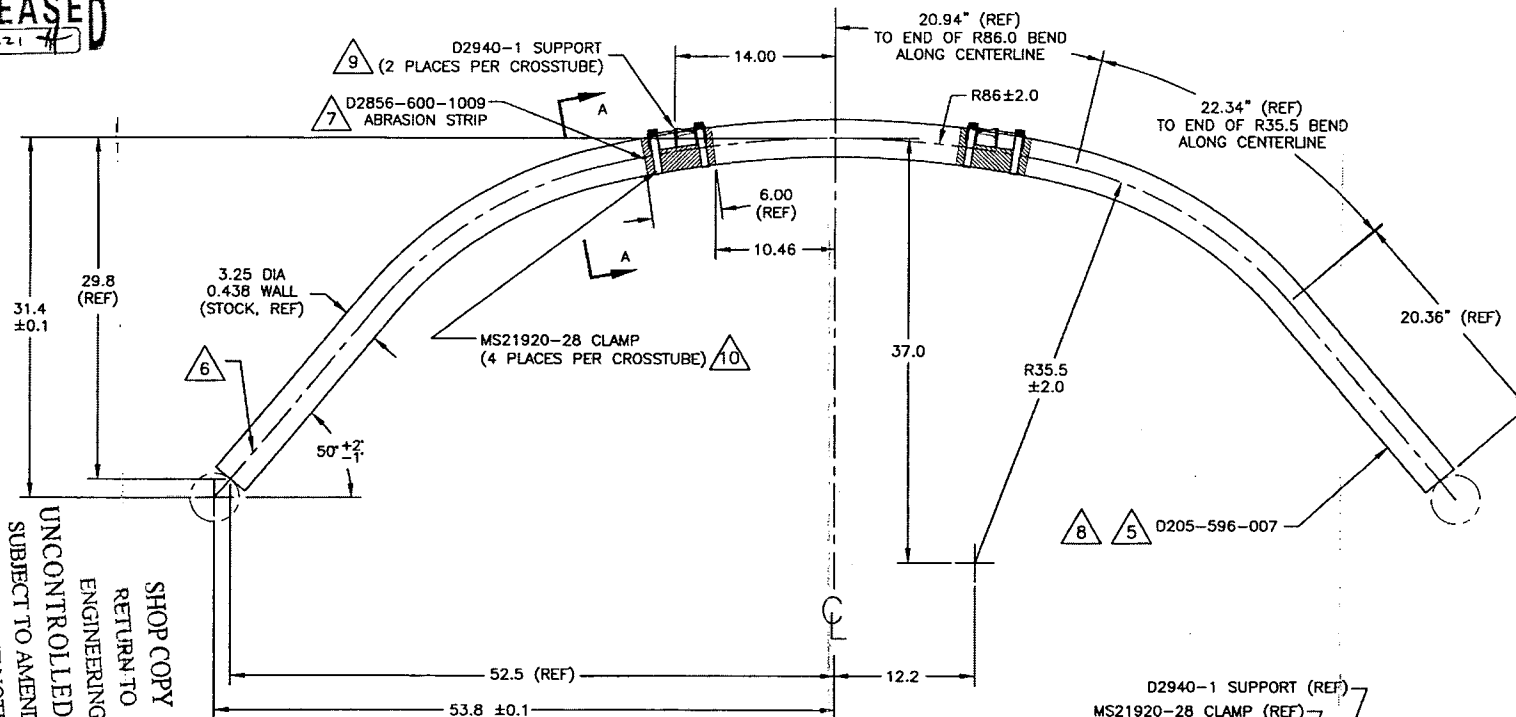


Comments

QC15 Inspection	<i>EP</i>
Date	07/07/06

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

RELEASED
02-11-21



GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURE FROM D6008-180
FINISHED LENGTH = 127.28
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 6) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
- 10) TORQUE CLAMPS 80 TO 100 IN-LB

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A		02.11.20	NEW ISSUE
DESIGN	✓	DRAWN BY	DART DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED	✓	APPROVED	DRAWING NO. D205-596-107
DATE	02.11.20	TITLE	CROSSTUBE AFT EXTENDED
		SCALE	1:10



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32357

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 User: Kim Johnston

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Estimate Number	: 10563		
P.O. Number	:	Part Number	: D205596107
This Issue	: 5/16/2007 S.O. No. :	Drawing Number	: D205596107
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: A
Previous Run	: 31379	Material	:
Written By	: <u>AD 07.05.16</u>	Due Date	: 6/15/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: D-05.03.21 Added bending procedure KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-107CHG001

07.05.30 AD

2.0	D2890	Aft Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2890 Aft Crosstube

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

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4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-107

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

REFERENCE ONLY